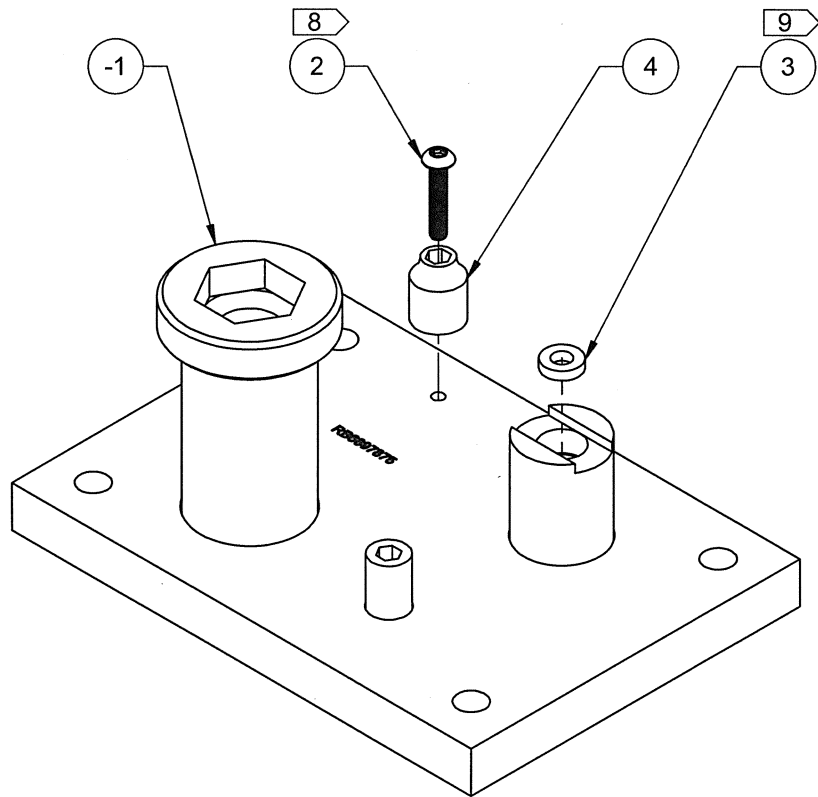
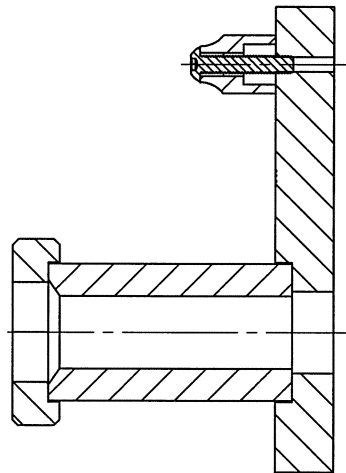
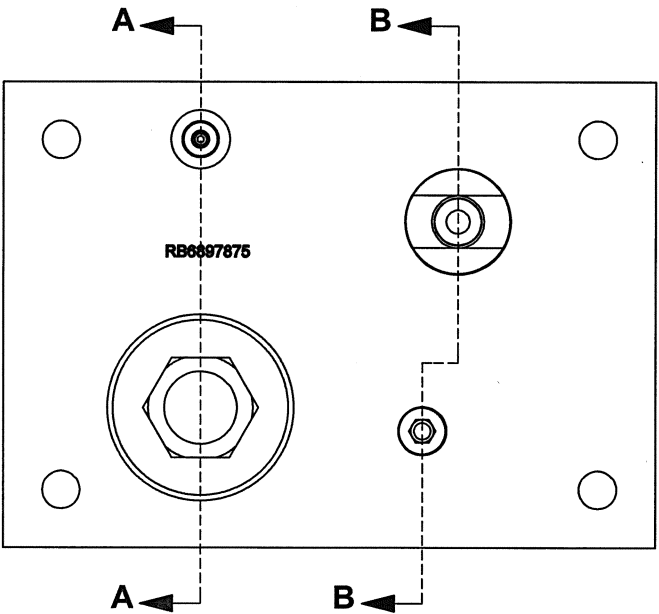
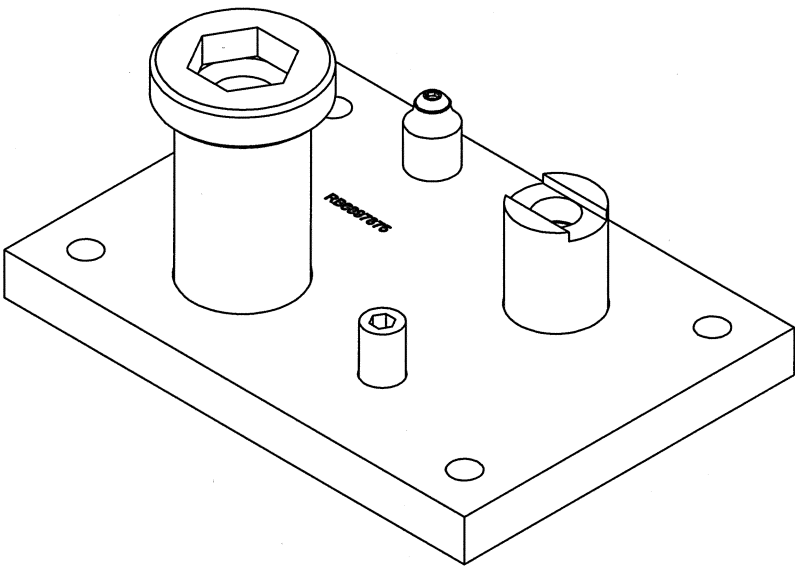


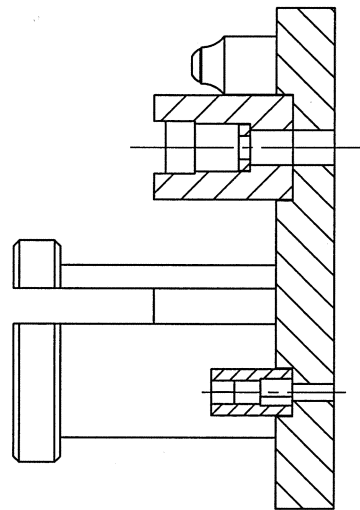
ITEM #	QTY	PART #	PART TITLE
-1	1	RB6897875-1	WELDMENT ASSY
2	1	McMaster#91255A273 OR EQUIV	BLACK OXIDE STEEL BUTTON HEAD HEX DRIVE SCREW #10-32 X 1" LG.
3	1	McMaster#90176A153 OR EQUIV	NYLON SPACER FOR 1/4" SCREW SIZE X 1/2" OD X 1/8" THK
4	1	MSC#48725303 OR EQUIV	6 POINTS STANDARD HAND SOCKET 1/4" X 3/8" DRIVE X 13/16" LG.



**RB6897875 FUEL NOZZLE HOLDING FIXTURE**



**SECTION A-A**



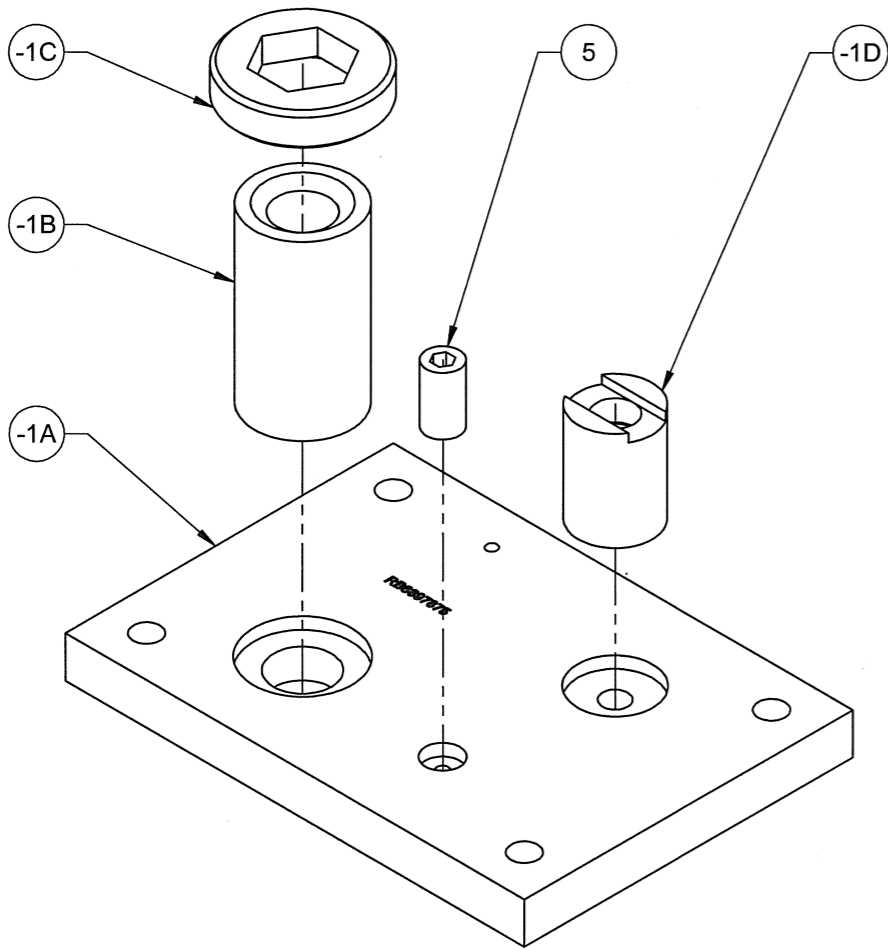
**SECTION B-B**

**NOTES:**

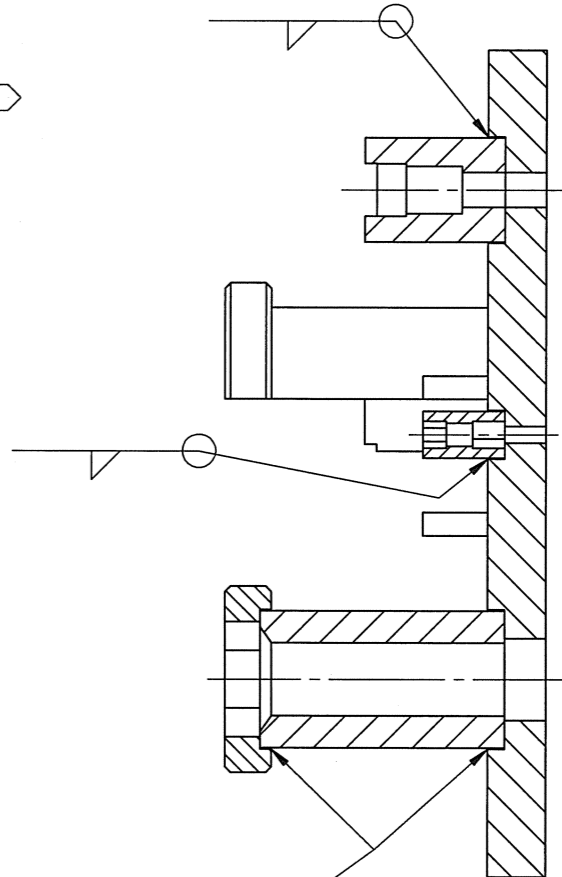
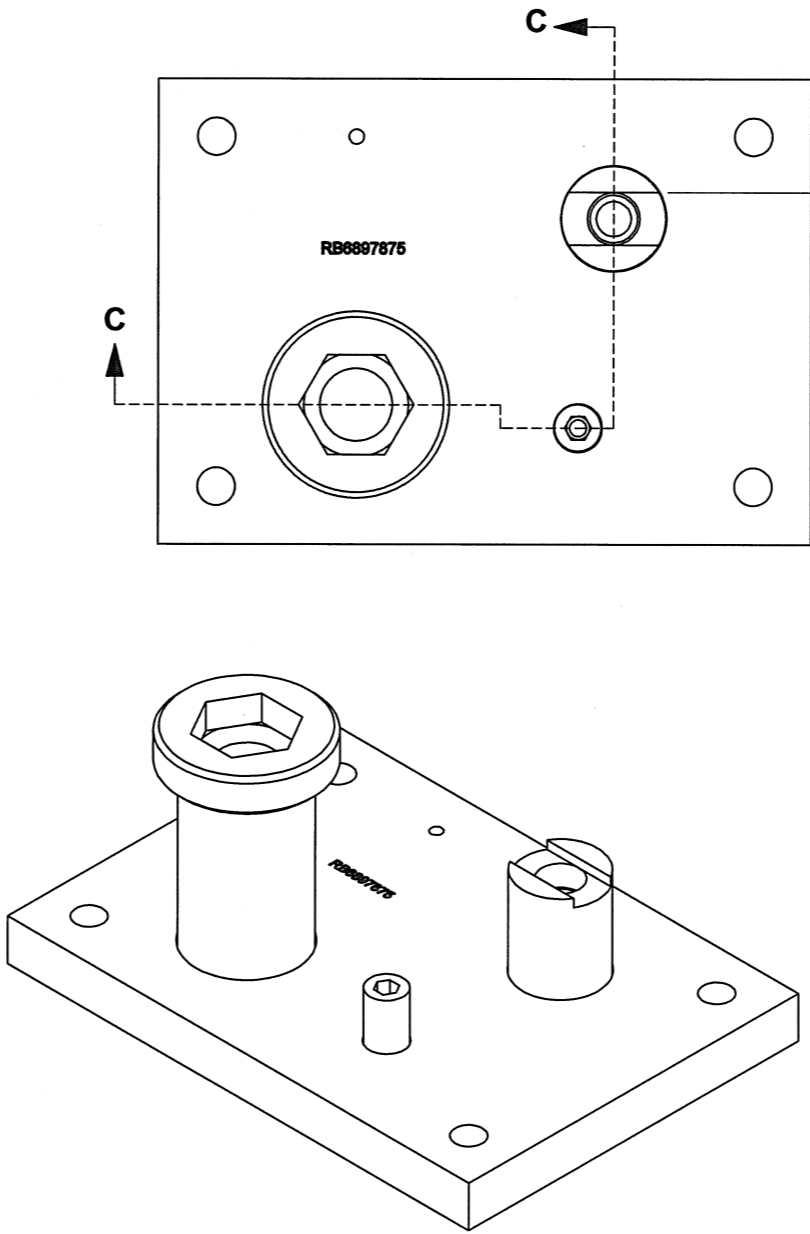
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 2 HAND TIGHT
- 9) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES  
THEN PRESS FIT ITEM 3 WITH ITEM -1, AND REMOVE EXCESS
- 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

FOR OLDER REV's SEE PREVIOUS PDFs TEMPLATE UPDATED PER DART HBY STANDARDS ITEM -5 CHANGED FOR ITEM 3 ITEM -3 CHANGED FOR ITEM 5 ITEM -7 CHANGED FOR ITEM 2 ITEM -2 CHANGED FOR ITEM 4 PURCHASE PART McMaster#90176A153 ITEM -1 WELD SYMBOL CORRECTED, ENGRAVE T/N,MADE IN USA & S/N REMOVED ITEM -9 DOWEL PIN MCMaster-CARR #98381A172 REMOVED ITEM -1A DIMENSION .1271/.1261 FOR DOWEL PIN REMOVED, MATERIAL A36/1018/1020 HR CHANGED FOR 4140 (28-32 Rc), HOLES DIMENSIONS CHANGED FOR LOOSER TOLERANCES, ENGRAVING T/N ADDED ITEM -1B DIMENSION 1.500/1.496 CHANGED FOR 1.47, DIMENSION 2.620 CHANGED FOR 2.62 ITEM -1C DIMENSION 2.00 +/-0.03 CHANGED FOR 2.00, DIMENSION 1.514/1.508 CHANGED FOR 1.50, MATERIAL 4140/4142 RC 28-32 CHANGED FOR O1 48-52 Rc ITEM -1D HOLES DIMENSIONS CHANGED FOR LOOSER TOLERANCES, DIMENSION 1.125/1.121 CHANGED FOR 1.120, DOWEL PIN HOLE REMOVED, DIMENSION .310 CHANGED FOR 0.375 + 0.005"/- 0, DIMENSION .5150/.5143 CHANGED FOR 0.5100, MATERIAL 4140/4142 RC 28-32 CHANGED FOR O1 48-52 Rc		19-744	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. D
MFG. APPR.	JFC	<b>RB6897875</b>	SHEET 1 OF 6
APPROVED	WJ	TITLE	SCALE
DATE <b>2019-05-24</b>		<b>FUEL NOZZLE HOLDING FIXTURE</b>	NTS
COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



ITEM #	QTY	PART #	PART TITLE
-1A	1	RB6897875-1A	BASE
-1B	1	RB6897875-1B	RISER 1
-1C	1	RB6897875-1C	TOP
-1D	1	RB6897875-1D	RISER 2
5	1	SNAP-ON#IMTM8A OR EQUIV	1/4" DRIVE 6 POINT SAE 1/4" FLANK DRIVE, SHALLOW IMPACT SOCKET

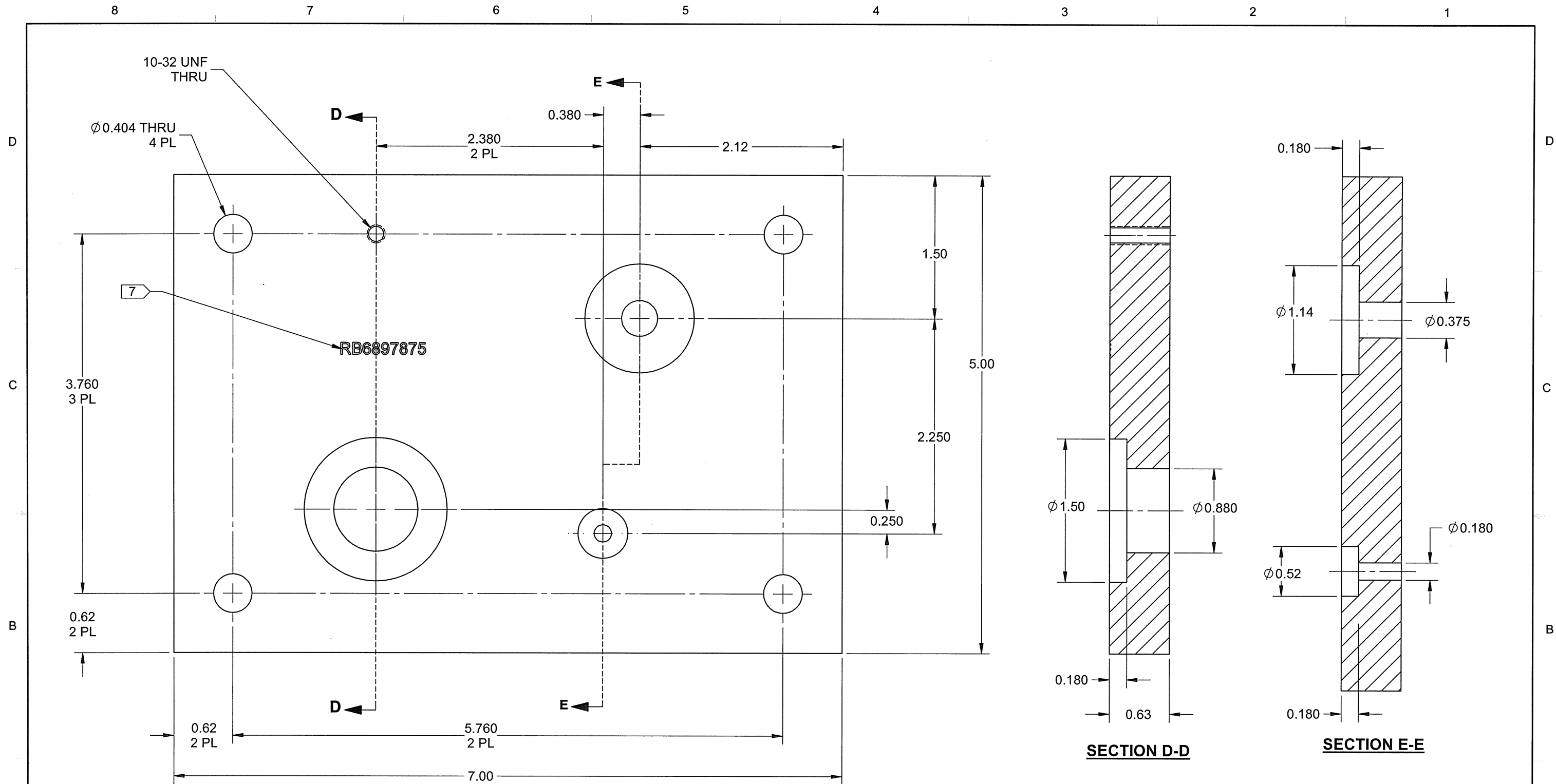


**RB6897875-1 WELDMENT ASSY**



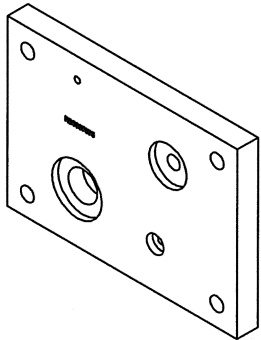
- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) IDENTIFICATION: N/A
  - 7) ASSEMBLE AS SHOWN
  - 8) ALIGN PARALLEL TO LONG EDGE OF ITEM -1A
  - 9) REMOVE WELD SPATTERS



DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. D
MFG. APPR.	JFC	<b>RB6897875</b>	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DATE 2019-05-24		<b>FUEL NOZZLE HOLDING FIXTURE</b>	NTS 
COPYRIGHT © 2019 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



**RB6897875-1A BASE**

NOTES:  
1) MATERIAL: 4140 (28-32 RC)  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) REMOVE ALL SHARP EDGES AND BURRS  
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RB6897875", AS SHOWN



DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. D
MFG. APPR.	JFC	RB6897875	SHEET 3 OF 6
APPROVED		TITLE	SCALE
		FUEL NOZZLE HOLDING FIXTURE	NTS 
DATE	2019-05-24	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8

7

6

5

4

3

2

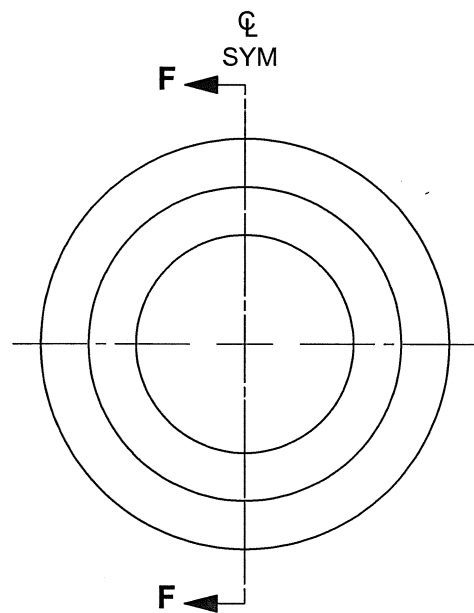
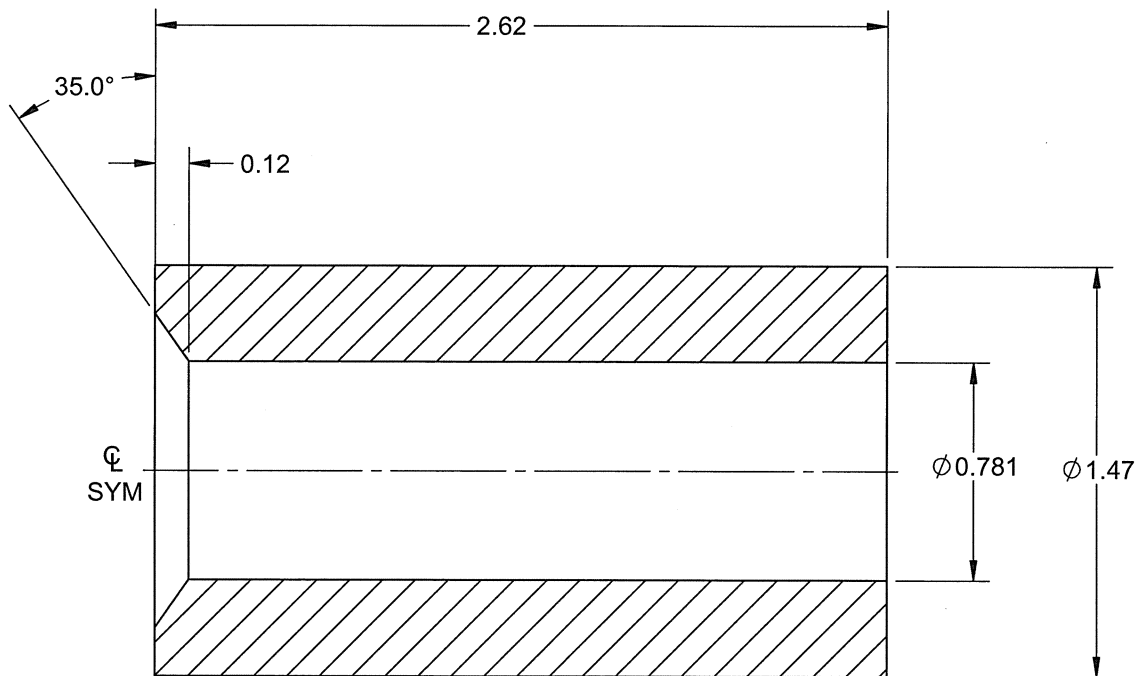
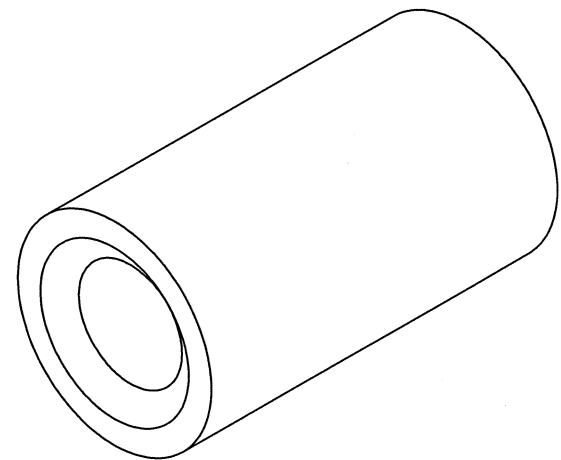
1

D

C

B

A

**RB6897875-1B RISER 1****SECTION F-F**

D

C

B

A

**NOTES:**

1) MATERIAL: 4140 (28-32 RC)

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°


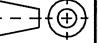
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. D
MFG. APPR.	JFC	<b>RB6897875</b>	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DATE	2019-05-24	<b>FUEL NOZZLE HOLDING FIXTURE</b>	NTS 
COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

8

7

6

5

4

3

2

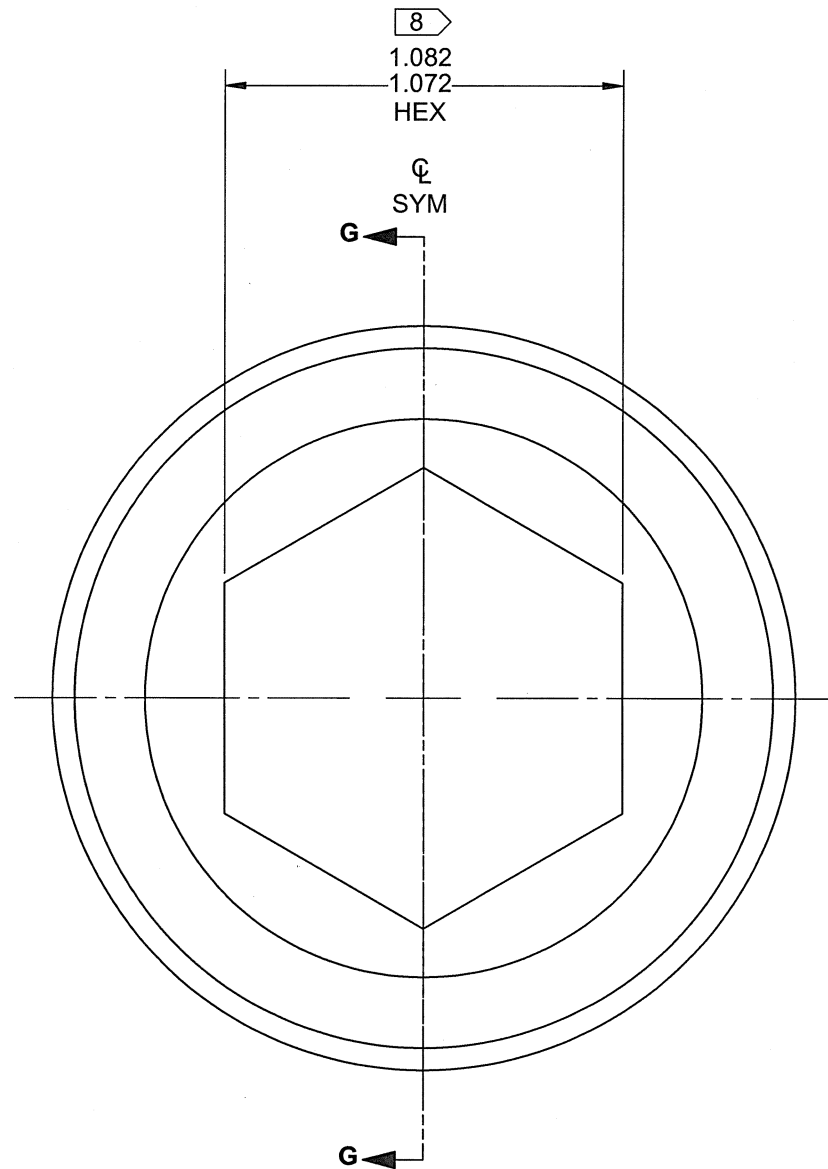
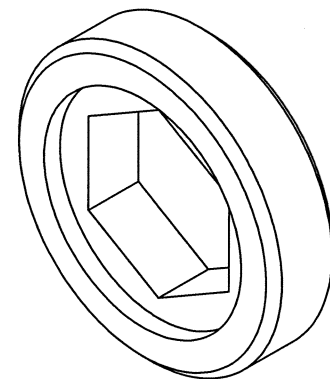
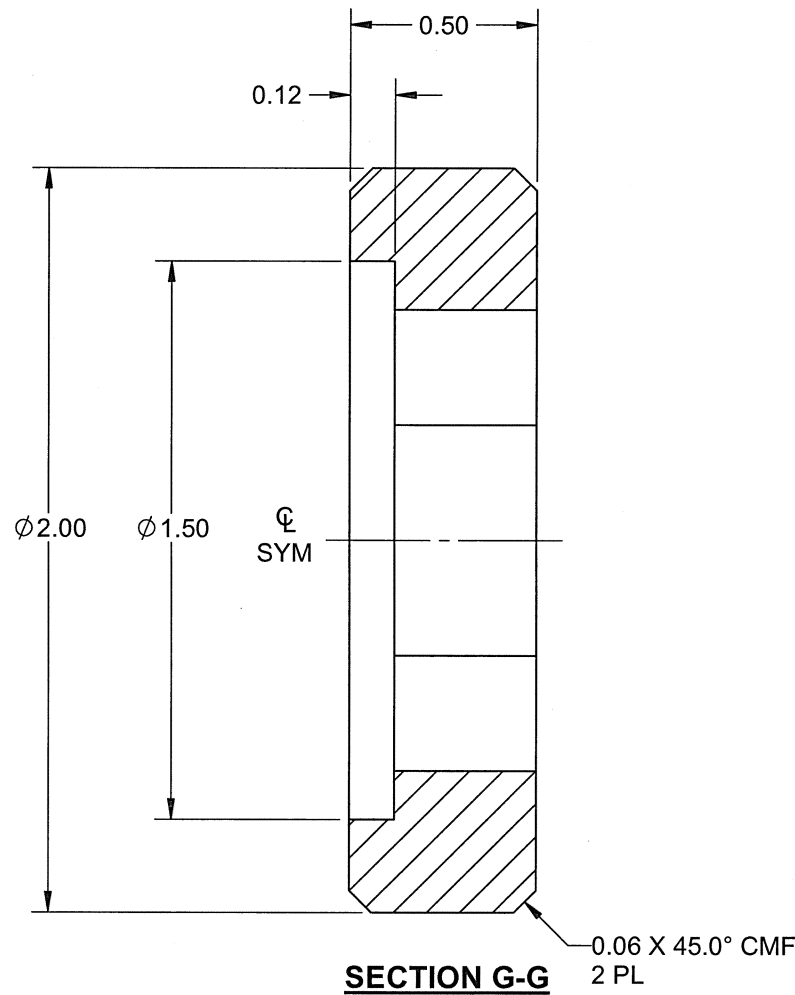
1

D

C

B

A

**RB6897875-1C TOP**

D

C

B

A

**NOTES:**

1) MATERIAL: O1

2) HEAT TREAT: 48-52 Rc

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°



PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

8) BROACH CORNERS CAN BE RELIEVED WITH 1/16" DRILL DIA. IF NECESSARY

DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. D
MFG. APPR.	JFC	RB6897875	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DATE 2019-05-24		FUEL NOZZLE HOLDING FIXTURE	NTS 
COPYRIGHT © 2019 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8

7

6

5

4

3

2

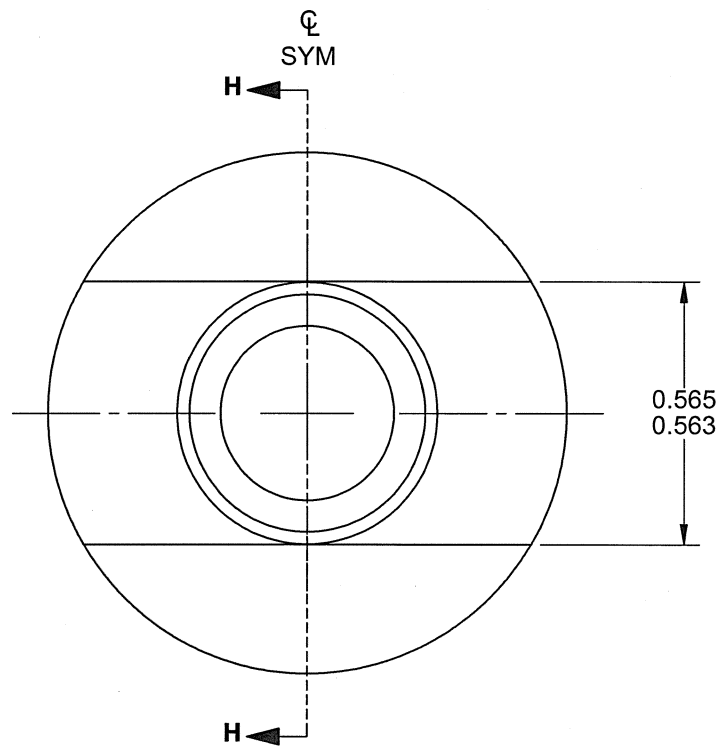
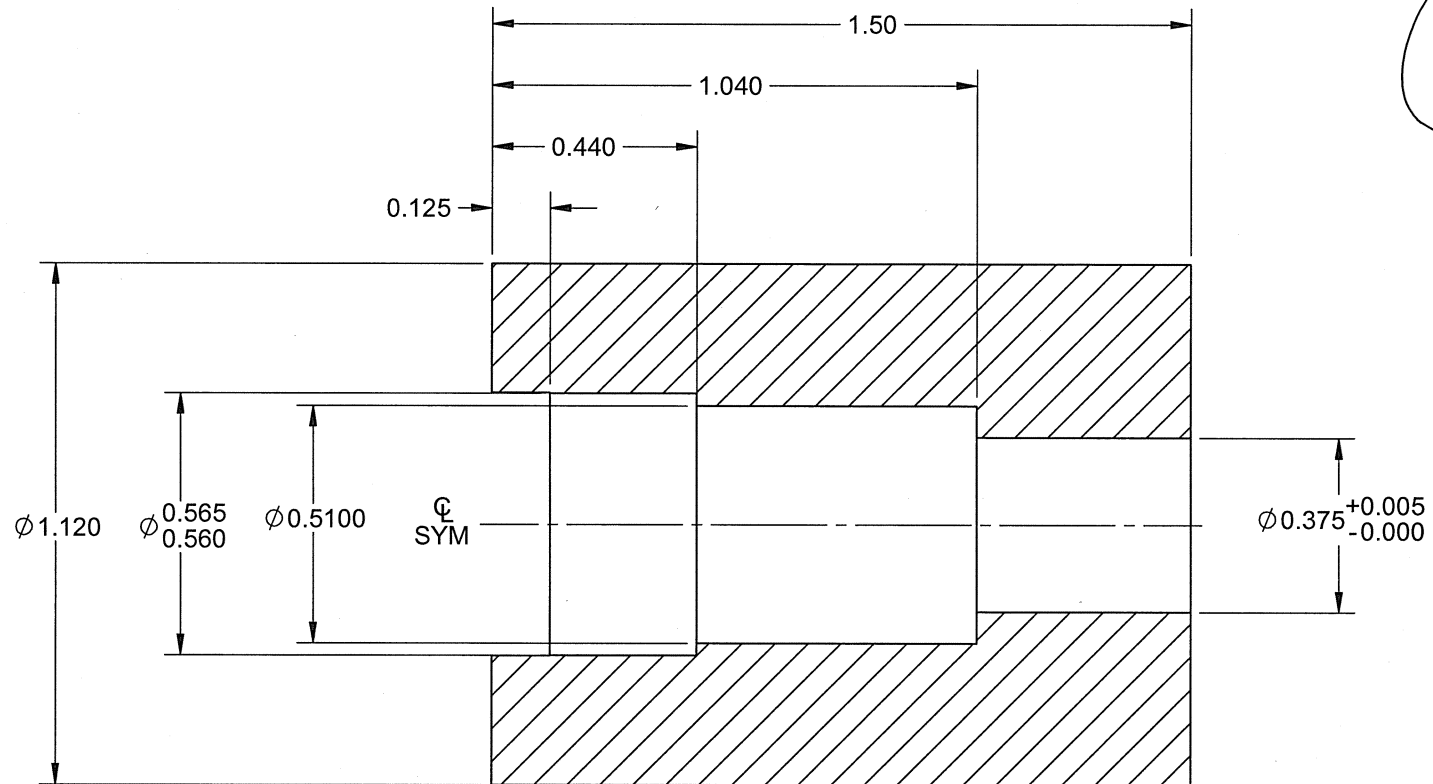
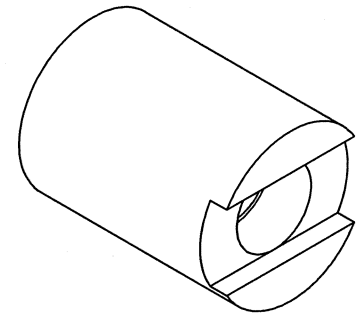
1

D

C

B

A

**RB6897875-1D RISER 2****SECTION H-H**

D

C

B

A

**NOTES:**

- 1) MATERIAL: O1
- 2) HEAT TREAT: 48-52 Rc
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. D
MFG. APPR.	JFC	<b>RB6897875</b>	SHEET 6 OF 6
APPROVED		TITLE	SCALE
		<b>FUEL NOZZLE HOLDING FIXTURE</b>	NTS
DATE	2019-05-24	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	